

Work Order ID 111137

111137

January-09-14 12:32:28 PM

Ru & S 14/01/23

Page 1

DPEI TRAIN ADV ISSUE
DPEI TRAIN ADV ISSUE

Item ID: D4634-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft, Center Ceiling Panel Assembly

Stop

NS2

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLP/MLJDate: 14-01-09

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4634

PD2 Per ECU 14-09
PET

0.00

100

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

SAO
14/01/23

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D4634-045 ✓

2- install No Smoking & seat belt symbols ✓

3- Install led lights ✓

4- Install Air valves ✓

5-Install Wiring Harness ✓

~~5-Install wiring harness~~X1
SAO
14/01/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111137

January-09-14 12:32:28 PM

111137

Page 2

Item ID: D4634-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 14-01-24 AUTH u

RELEASED 5 DATE 14/01/24

POSITIVE RECALL

EFFECTIVE 14-01-24 AUTH u

RELEASED DATE

DAS

27

9-89

Release

Dwg

as per Rev E

14/1/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Picklist Print

Thursday, January 23, 2014 8:22:30 AM

Page 1

Work Order ID: 111137

Parent Item: D4634-045

Parent Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
DL VERIFIED BY:JLM
IPP Rev D Dwg Update 13/12/23 DL
IPP Rev B 12/11/08 Doc release
IPP Rev C Dwg Update 13/07/09 DL verf: DD
IPP REV E Dwg Update 14/01/20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2351-20-27-C3C STUD		Purchased	No				Each	80.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST396		80							
				m126740		30							
				m127922		50							
50-009-2 Grommet		Purchased	No				Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST378		1							
				122594		1		m128022					
D4634-145 Aft, Center Ceiling Replacement Panel Assembly		Manufactured	No			100	Each	2.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		2							
				111158		1							
				111160		1							
D4646-1 Plenum Cap Assembly		Manufactured	No			100	Each	84.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		84							
				103832		66							
				92968		6							
				95779		12							

SAO¹ 14/01/22

SAO¹ 14/01/22

SAO¹ 14/01/23

SAO² 14/01/23

2

Picklist Print

Thursday, January 23, 2014 8:22:30 AM

Page 2

Work Order ID: 111137

Parent Item: D4634-045

Parent Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4652-1 Manufactured No 100 Each 215.0000

Air Valve, 1.16 Id Disk Type

2 SAD² 14/01/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
prelim	24	
111316	12	
111317	12	
ST099	191	
111311	191	

2

D4728-049 Manufactured No 100 Each 0.0000

Advisory Light, Aft

D4728-055 Manufactured No 100 Each 1.0000

Cabin Lights #3

1 SAD¹ 14/01/23

1 SAD¹ 14/01/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST121	1	
93458	1	

W/111208

①

PLT1.5M-M Purchased No 100 Each 1,008.0000

Tie Wrap

8 SAD⁸ 14/01/23

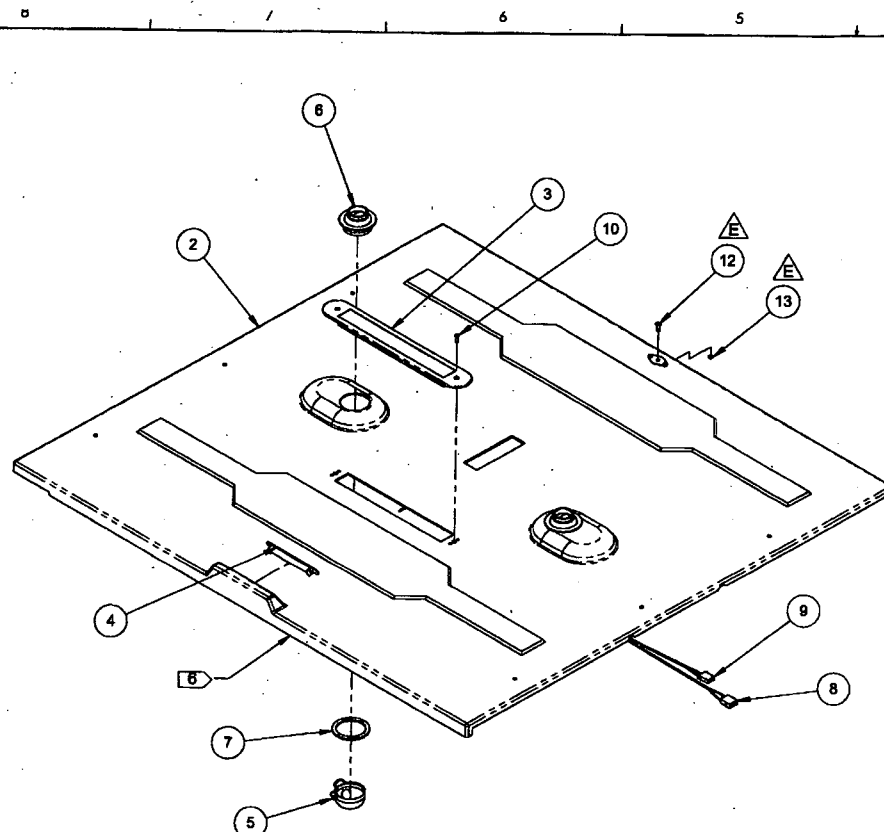
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST389	1008	
124363	8	
m126551	1000	

8

Thursday, January 23, 2014 8:22:30 AM

Shop Packet Print

Page 2



ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4634-045	AFT, CENTER CEILING PANEL ASSY
2	1	D4634-145 ✓	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (PART OF D4728-055)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-049)
5	2	D4646-1 ✓	PLENUM CAP ASSEMBLY
6	2	D4652-1 ✓	AIR VALVE
7	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
8	1	D4728-049 ✓	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
9	1	D4728-055 ✓	CABIN LIGHT #3 ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4728-055)
11	10	PLT1.5M-M ✓	TIE-WRAP (OR PLT1.5M-C)
12	1	2351-20-27-C3C	STUD
13	1	50-009-2	GROMMET

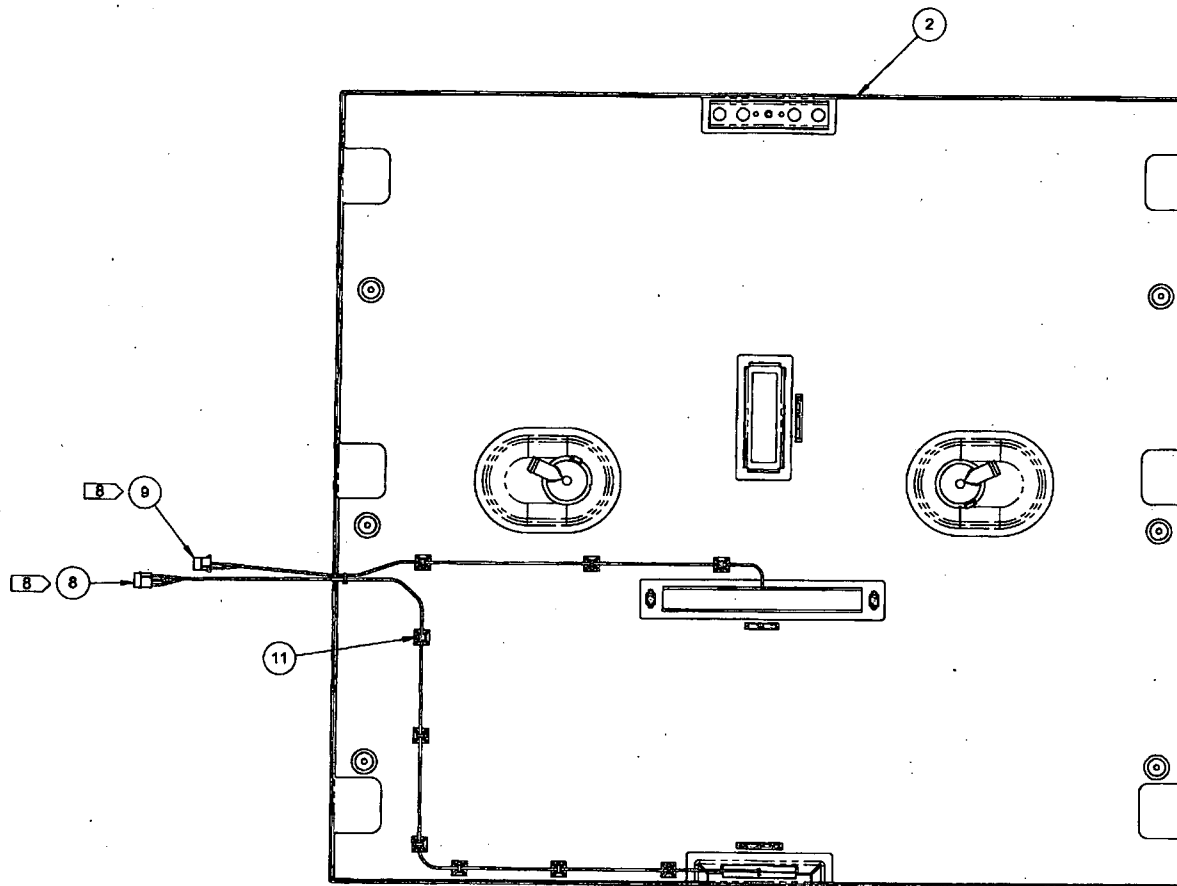
D4634-045 AFT, CENTER CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.5 lbs
- 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

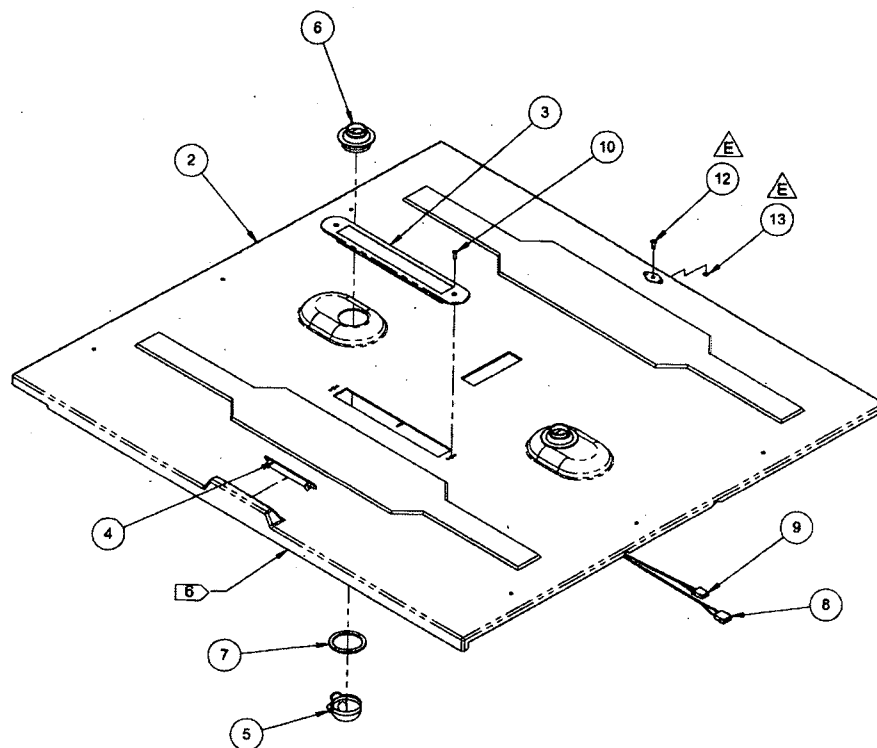
64 2014-07-22
MD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4634	SHEET 6 OF 17
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4634-045 AFT. CENTER CEILING PANEL ASSY
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	D4634	SHEET 6 OF 17
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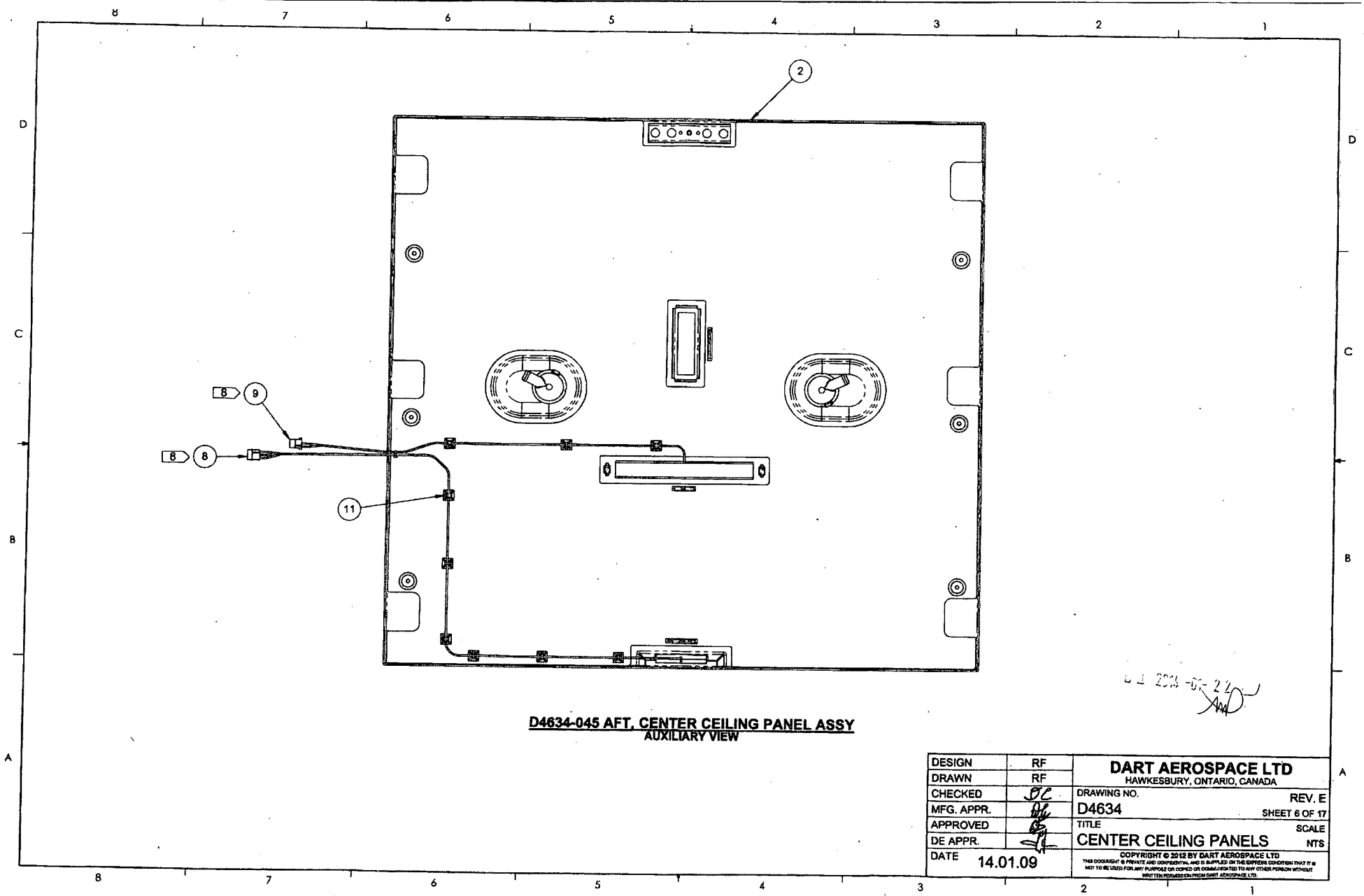
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3	1	D4638-1 (REF)	LED LIGHT (PART OF D4728-055)
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12	1	2351-20-27-C3C	STUD
13	1	50-009-2	GROMMET

D4634-045 AFT, CENTER CEILING PANEL ASSY

NOTES:

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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.5 lbs
- 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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